

Ship Oct. 25

Work Order ID 62586 - 2

Monday, October 04, 2010 3:21:46 PM



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Item ID: D206-628-022BL

Revision ID:

Item Name: Heli-Access-Step RH, Blue

Start Date: 10/5/2010 Start Qty: 4.00

Required Date: 10/29/2010 Req'd Qty: 4.00

Reference:

Accept



Setup

Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: MF

Date: 10-10-04 Tooling:

Date:

Run

Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100		0.00							



DOCUMENT CONTROL

DC

Document Control

Memo

0.00

Photocopy blue file and type labels as per PPP D206-628-022 CHG.003

✓ S 10/10/09

✓ for BG 10-10-13

110



Pick Kit

0.00

10/10/13 sf

Memo

0.00

120



QC4- 100% Inspect kits for completeness

0.00

S 10/11/09

✓ RH

QC

Quality Control

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Item ID: D206-628-022BL

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step RH, Blue

Stop



Start Date: 10/5/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Packaging

Operation
Description

Packaging

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Packaging

Memo

0.00

10/11/9 SL PD

140



QC

QC21- Final Inspection - Work Order Release

0.00

Quality Control

Memo

0.00

10/11/9 SL

SL
10-11-9

Picklist Print

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Work Order ID: 62586



Parent Item: D206-628-022BL



Parent Item Name: Heli-Access-Step RH, Blue

Start Date: 10/5/2010

Required Date: 10/29/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevF: add D2724-042 DD 09.11.17 verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN4-14A		Purchased	No				Each	168.0000	4	16			
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Bolt

Location	Loc Qty	Loc Code
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ST357	152	
-------	-----	--

114752	1	
--------	---	--

<u>115371</u>	150	
---------------	-----	--

115422	1	
--------	---	--

ST358	16	
-------	----	--

113359	16	
--------	----	--

	Each	
--	------	--

	577.0000	
--	----------	--

	8	
--	---	--

AN4-15A		Purchased	No				Each	577.0000	8	32			
---------	--	-----------	----	--	--	--	------	----------	---	----	--	--	--



Bolt

Location	Loc Qty	Loc Code
----------	---------	----------

ST338	112	
-------	-----	--

ST358	465	
-------	-----	--

107737	12	
--------	----	--

108868	60	
--------	----	--

109148	4	
--------	---	--

111295	52	
--------	----	--

112905	12	
--------	----	--

114232	3	
--------	---	--

114292	32	
--------	----	--

<u>114615</u>	56	
---------------	----	--

114784	58	
--------	----	--

115108	76	
--------	----	--

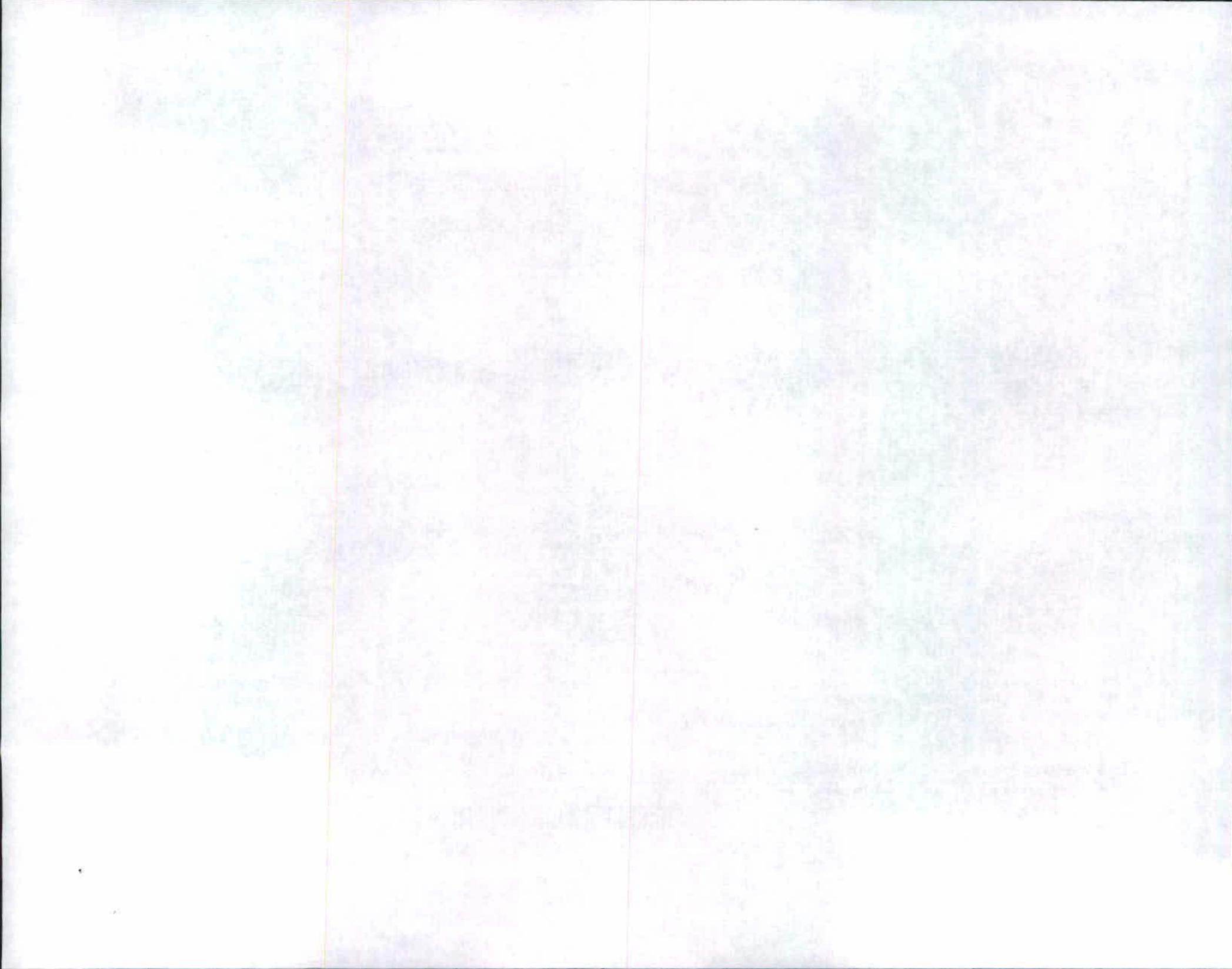
115371	100	
--------	-----	--

10/10/10 SP

10

10/10/10 SP

31



Picklist Print

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Work Order ID: 62586



Parent Item: D206-628-022BL



Parent Item Name: Heli-Access-Step RH, Blue

Start Date: 10/5/2010

Required Date: 10/29/2010

Start Qty: 4.00

Required Qty: 4.00

A AN960JD416



Washer

NAS1149D0463J Purchased

No

Each

24.0000

12

48



reorder M115647 sf

S D2724-042



206L Step Assembly

D2731-7



C Mounting Lug

Manufactured

No

Location

ST300

Loc Qty

24

Loc Code



113288

Each

0.0000

1



362589 10/10/2010

R D2732-030



Rubber Cushion

L D3394-043



M Lug Assembly

Manufactured

No

Location

ST420

Loc Qty

16

Loc Code



60996

Each

0.0000

8

32 x feet 10/10/2010

ST470

16

59202

39

61653

15

24

Each

0.0000

8

362589 10/10/2010

Manufactured

No

Location

ST420

Loc Qty

19

Loc Code



60997

Each

31.0000

4

16

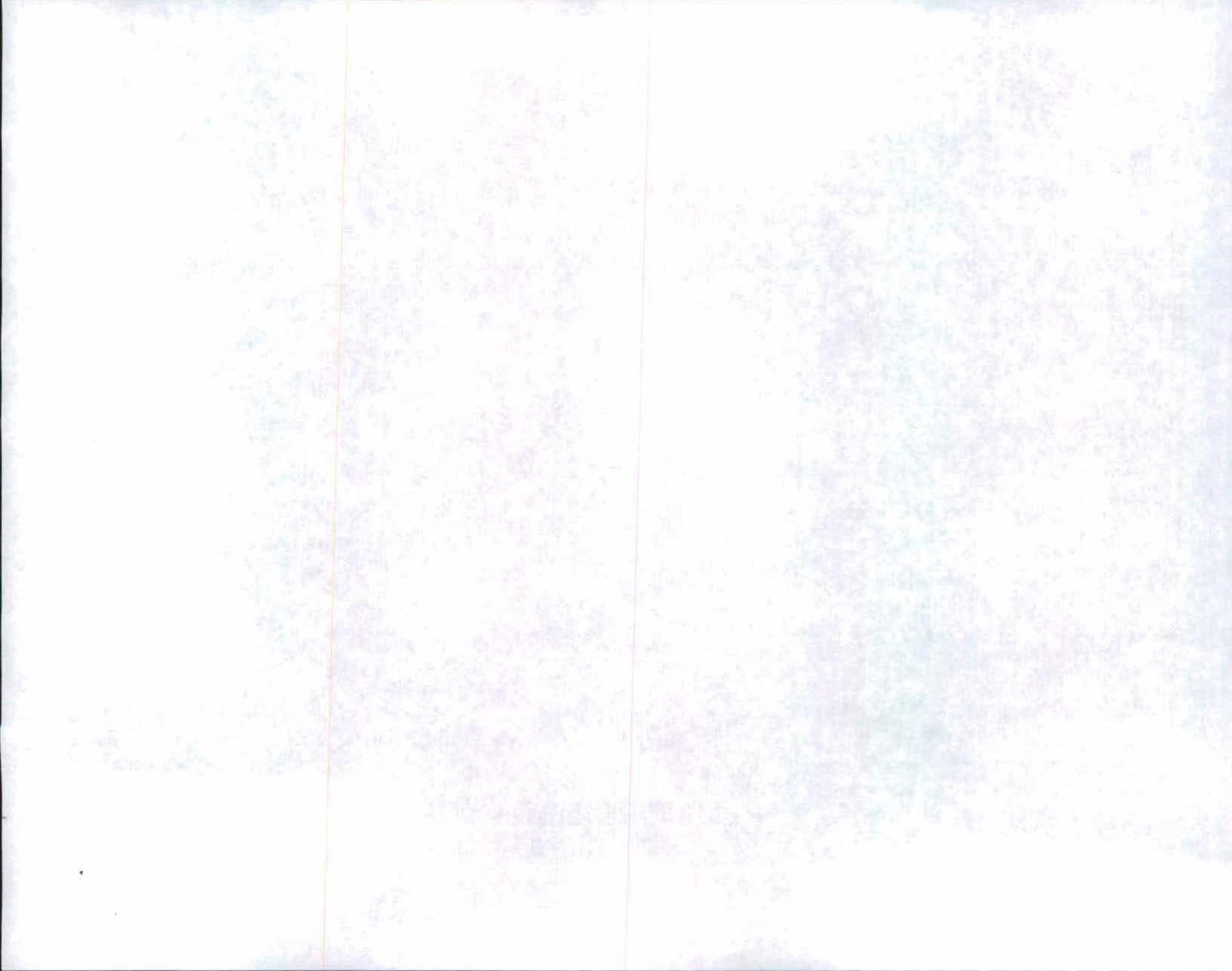
362589 10/10/2010

ST475

19

52331

12



Picklist Print

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Work Order ID: 62586



Parent Item: D206-628-022BL



Parent Item Name: Heli-Access-Step RH, Blue

Start Date: 10/5/2010

Required Date: 10/29/2010

MS21042L4



Purchased

No

Each

4,434.000

12

48



Nut

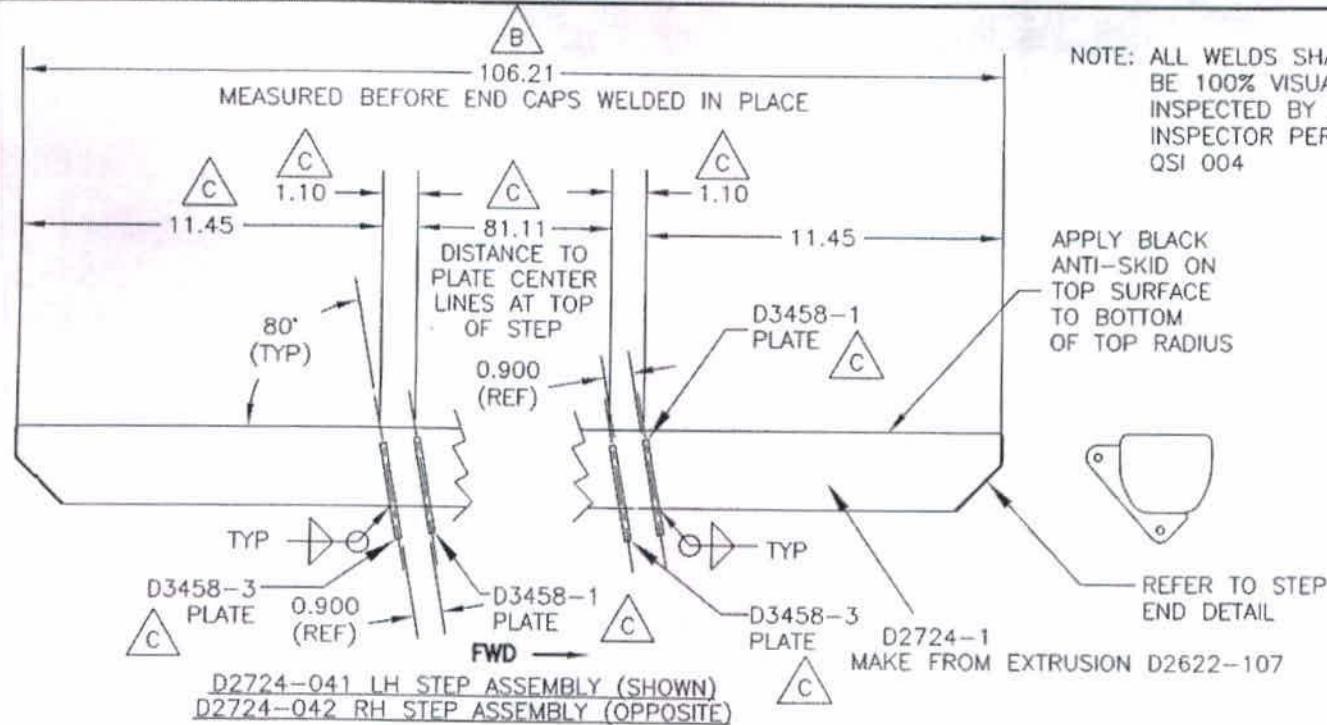
10/10/10 Sy (40)

Location	Loc Qty	Loc Code
ST300	4434	
113422	68	
114523	8	
114718	16	
114784	32	
115108	1310	58
115589	1900	
115621	1100	

**5.1 D206-628-011/-012/-021/-022/-031/-032 REGULAR DART HELI-ACCESS-
STEPS™ PARTS LIST**

Qty -011	Qty -012	Qty -021	Qty -022	Qty -031	Qty -032	Part Number	Description
X						D206-628-011	206 A/B STEP INSTALLATION LH
	X					D206-628-012	206 A/B STEP INSTALLATION RH
		X				D206-628-021	206 L/L1/L3/L4 STEP INSTALLATION LH
			X			D206-628-022	206 L/L1/L3/L4 STEP INSTALLATION RH
				X		D206-628-031	407 STEP INSTALLATION LH
					X	D206-628-032	407 STEP INSTALLATION RH
1						D2721-041	STEP ASSEMBLY LH
	1					D2721-042	STEP ASSEMBLY RH
		1		1		D2724-041	STEP ASSEMBLY LH
			1		1	D2724-042	STEP ASSEMBLY RH
2	2			4	4	D2731-3	MOUNTING LUG
2	2	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
2	2			4	4	D3394-041	MOUNTING LUG
2	2			4	4	*D3394-1	*MOUNTING LUG
4	4			8	8	*MS35489-93	*GROMMET
2	2	4	4			D3394-043	MOUNTING LUG
2	2	4	4			*D3394-3	*MOUNTING LUG
4	4	8	8			*MS35489-93	*GROMMET
4	4			4	4	AN4-13A	BOLT
4	4	4	4	4	4	AN4-14A	BOLT
4	4	8	8	4	4	AN4-15A	BOLT
12	12	12	12	12	12	AN960JD416	WASHER
12	12	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE



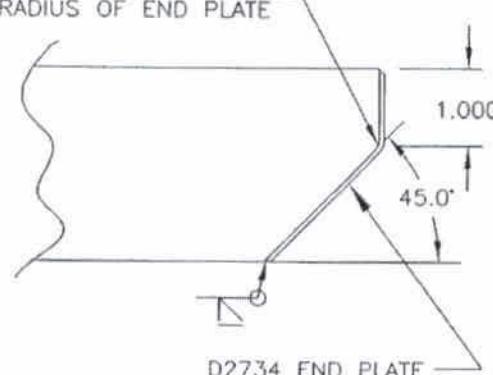
D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
X		D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

B

DESIGN KEY	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2724
DATE		REV. C SHEET 1 OF 1
05.09.19	#	TITLE 206L/407 STEP ASSEMBLY
A	97.12.04	NEW ISSUE
B	98.10.19	UPDATED WELD DETAIL REVISED TOLERANCES
C	05.09.19	RE-DESIGN, ADD D3458-1/-3
		SCALE NTS

